

Date: Monday, 9/10/2007 1:19:06 PM
User: Kim Johnston

Process Sheet

Split 3

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : ARM
Job Number : 34477
Estimate Number : 12884
P.O. Number : *N/A*
This Issue : 9/10/2007 S.O. No. : *N/A*
Prsht Rev. : NC
First Issue : *N/A* Type : SMALL /MED FAB
Previous Run : 32648
Written By :
Checked & Approved By :
Comment : Est Rev:A New Issue 07.05.24 EC

Part Number : D3560044
Drawing Number : D3560 UNDER REVIEW
Project Number : N/A
Drawing Revision : *EC*
Material : *N/A*
Due Date : 9/17/2007 Qty: *12* Um: *EA*

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M6061T6B0500X05000

6061-T6 Bar 50" x 5.0"



Comment: Qty.: 1.3598 f(s)/Unit Total : 16.3170 f(s)

6061-T6 Bar 0.50" x 5.00"

Batch: *M105646**7nd 07/09/20*

2.0

BAND SAW

BAND SAW



Comment: BAND SAW

Cut blanks 15.500" long

7nd 07/09/20

3.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA696 Rev: *K* & Dwg D3560 Rev: *C*

2-C'sink 0.196" hole on manual mill as per dwg D3560

3-Deburr per dwg D3560

2F 07/09/20

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

2F 07/09/20

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.F. 07/09/20

Date: Monday, 9/10/2007 1:19:06 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 34477

Part Number: D3560044

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

D35921

PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

PLATE ~~334260~~ 334478 = 1

07.10.29 (1)

07.10.1

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3560

07.10.29 (1)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

6/10/03

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07-10-31 (1)

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FD 07/11/01 (1)

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Q

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07-11-02

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *WA*

07-11-01 (1)

Date: Monday, 9/10/2007 1:19:06 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 34477

Part Number: D3560044

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Handwritten: (1)
DAR/11/02

Job Completion



Handwritten: Le 07.11.02

DART AEROSPACE LTD		Work Order:	34477
Description: Arm		Part Number:	D3560-4
Inspection Dwg: D3560	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.507	+0.000/-0.001	.506	/			
Ø0.196	+0.005/-0.001	.197				
Ø1.000	+0.010/-0.001	1.003				
Ø0.900	+0.010/-0.001	.900				
0.500	+/-0.010	.494				
0.250	+/-0.010	.252				
0.275	+/-0.010	.277				
0.188	+/-0.010	.190				
2.000	+/-0.010	2.006				
1.750	+/-0.010	1.746				
1.702	+/-0.010	1.704				
Ø0.385 x 100°	+/-0.010 x 0.5°	.378				
0.250 Deep	+/-0.010	.241				

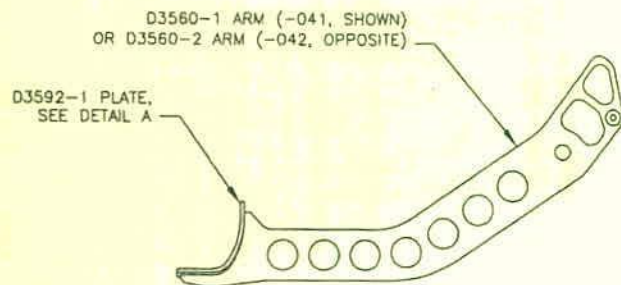
Measured by: J.F.	Audited by: JF	Prototype Approval:	N/A
Date: 07/09/22	Date: 07/09/22	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.01.17	New Issue	KJ/JLM	
B	07.06.13	Dimensions updated per Dwg Rev B	KJ/JLM	

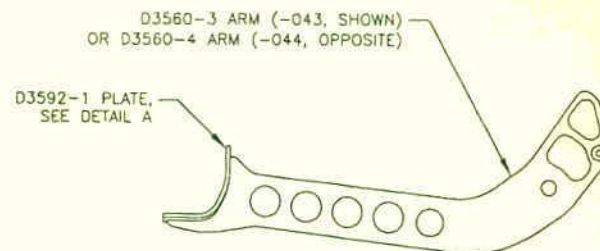
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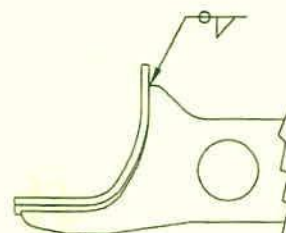
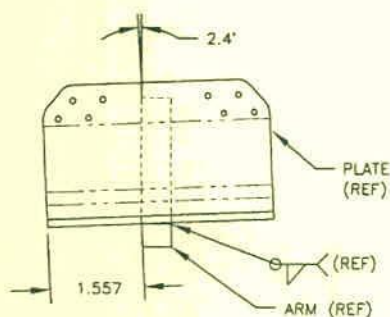
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D3560-041 ARM WELDMENT (SHOWN),
D3560-042 ARM WELDMENT (OPPOSITE)



D3560-043 ARM WELDMENT (SHOWN),
D3560-044 ARM WELDMENT (OPPOSITE)



DETAIL A
(SCALE 1:1)

GENERAL NOTES

- 1) WELD PER QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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07.06.19

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C	07.06.19	REMOVE POWDER COAT
B	07.01.15	REDESIGN AS WELDMENT, ADD POCKETS
A	06.09.25	NEW ISSUE
DESIGN	9P	DRAWN BY 9P
CHECKED	H	APPROVED H
DATE	07.06.19	TITLE
		ARM WELDMENT

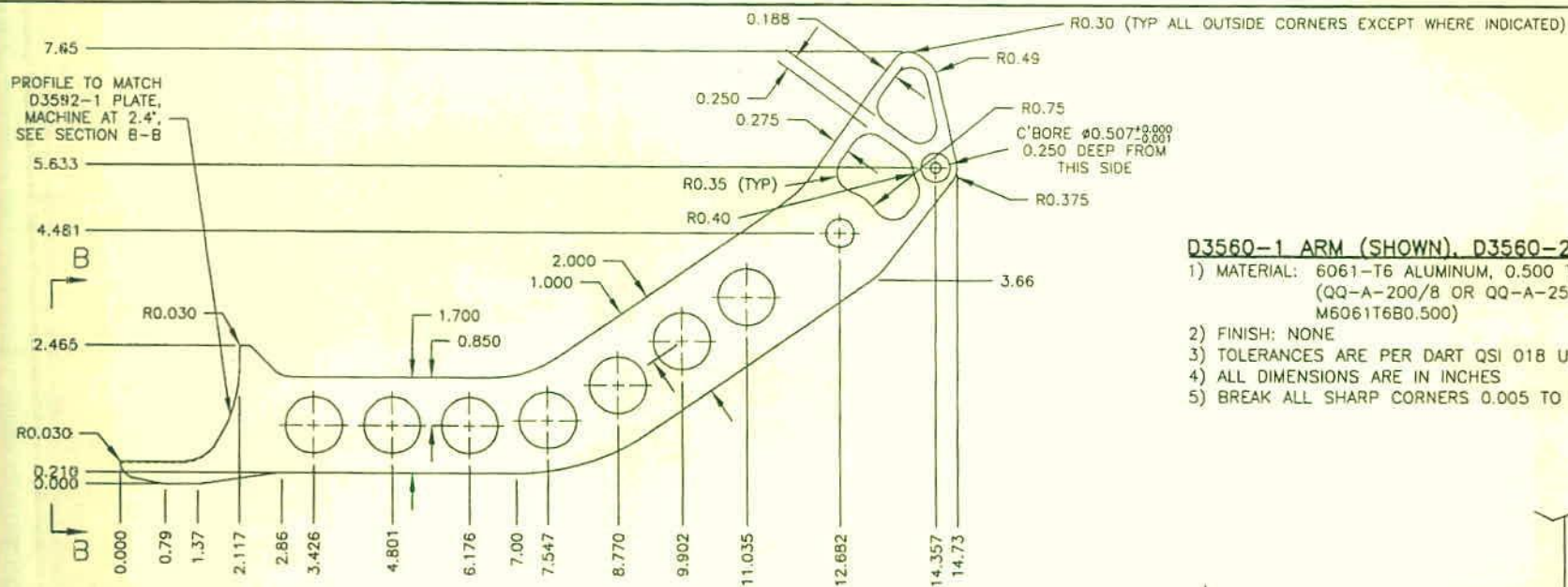
DART

DART AEROSPACE LTD.
MARKHAM, ONTARIO, CANADA

DRAWING NO.
D3560

REV. C
SHEET: 1 OF 3

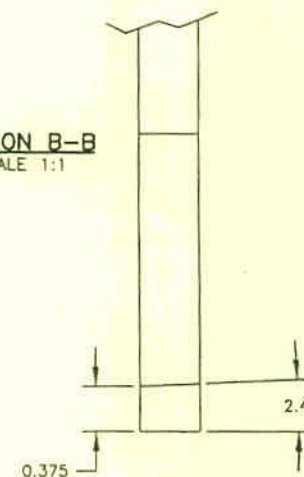
SCALE
1:4



D3560-1 ARM (SHOWN), D3560-2 ARM (OPPOSITE)

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.500 THICK
(QQ-A-200/8 OR QQ-A-250/11, REF DART SPEC.
M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.015

SECTION B-B SCALE 1:1



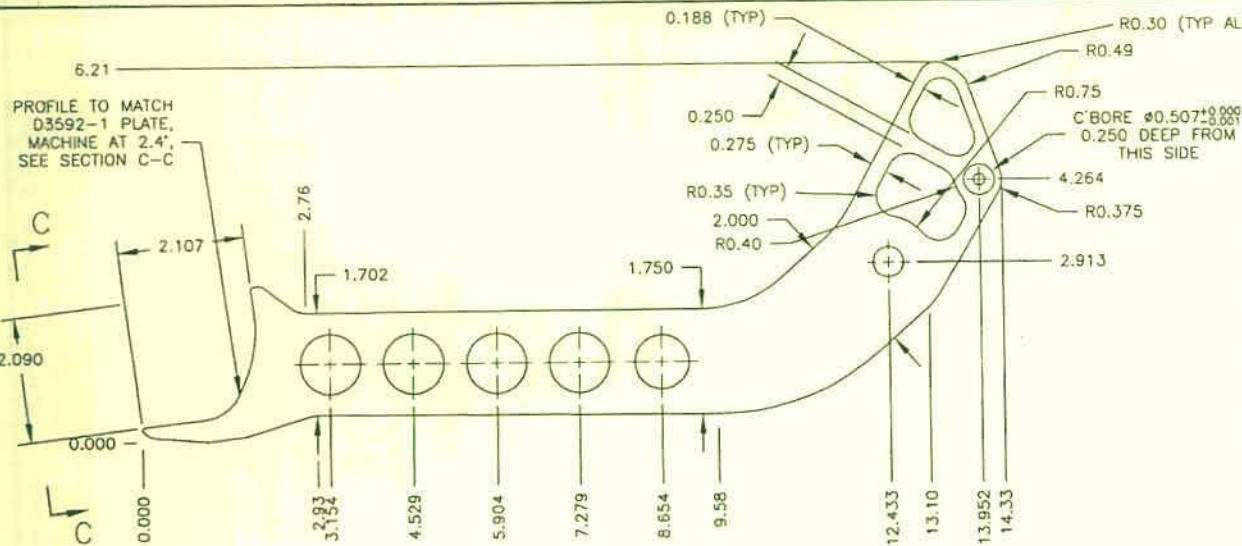
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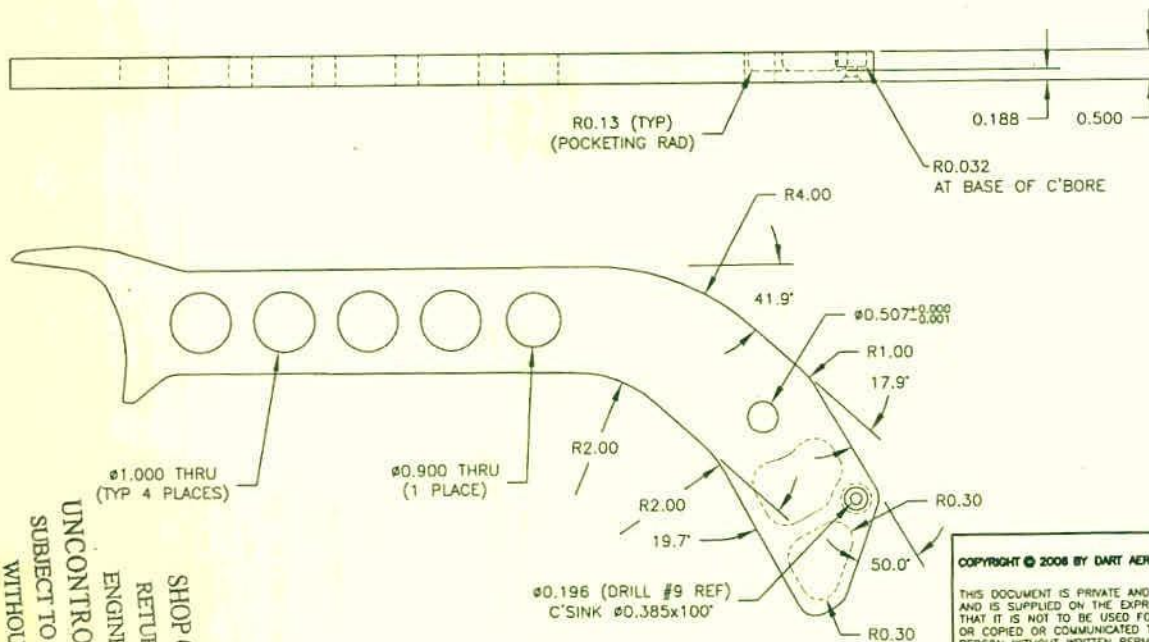
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CHECKED	h	APPROVED	h	DRAWING NO.	D3560
DATE	07.06.19	TITLE	ARM WELDMENT	REV. C	SHEET 2 OF 3
				SCALE	1:2

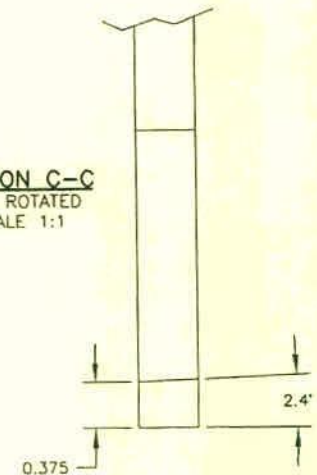


D3560-3 ARM (SHOWN), D3560-4 ARM (OPPOSITE)

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.500 THICK
(QQ-A-200/8 OR QQ-A-250/11, REF DART SPEC. M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.015



SECTION C-C VIEW ROTATED SCALE 1:1



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CHECKED	h	APPROVED	h	DRAWING NO.	REV. C
DATE	07.06.19			D3560	SHEET 3 OF 3
				TITLE	SCALE
				ARM WELDMENT	1:2

